

U.S. Express Mail Label No.: EU 928898591 US
Inventors: Hua Hsiang Lin and Yaw Yuan Hsu
Attorney Docket: 21169-170

What is claimed is:

1. A method for manufacturing a translucent laminate, said laminate consisting of at least one woven scrim layer disposed between at least two outer vinyl translucent layers; said method comprising:
 - a. A step for substantially coating said scrim with a suitable plastisol adhesive;
 - b. A step for substantially removing said adhesive from the interstices between the warp and fill of said scrim;
 - c. A step for heating said scrim and said adhesive to a suitable temperature for bonding said scrim and said adhesive to said outer vinyl layers;
 - d. A step for heating said outer vinyl layers to a suitable temperature for bonding with said adhesive and said scrim; and
 - e. A step for bringing said scrim and said vinyl layers together under sufficient pressure and at a suitable temperature such that the said outer vinyl layers bond to said scrim.
2. The method of claim 1 wherein the warp and fill strands of said scrim are comprised of a polyester material.
3. The method of claim 1 wherein the warp and fill strands of said scrim are comprised of a polyamide.
4. The method of claim 1 wherein the warp and fill strands of said scrim are comprised of an aromatic polyamide.

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5. The method of claim 1 wherein the warp and fill strands of said scrim are comprised of rayon.

6. The method of claim 1 wherein the adhesive used is comprised of a mixture of methyl ethyl ketone, isocyanate and polyurethane.

7. The method of claim 1 wherein the outer vinyl layers are comprised of a polyolefin.

8. The method of claim 1 wherein the outer vinyl layers are comprised of polyvinyl chloride.

9. The method of claim 1 wherein the outer vinyl layers are comprised of polyvinyl fluoride.

10. The method of claim 1 wherein the outer vinyl layers have a thickness between .225 mm to .4 mm.

11. The method of claim 1 wherein the outer vinyl layer has a thickness greater than .220mm.

12. The method of claim 1 wherein the warp and fill of the scrim are comprised of strands each with a thickness greater than 500 denier.

13. The method of claim 1 wherein the warp and fill of the scrim are comprised of strands with a thickness up to 2000 denier.

14. The method of claim 1 wherein the warp of the scrim is comprised of between 3 to 20 strands per inch.

15. The method of claim 1 wherein the fill of the scrim is comprised of between 3 to

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20 strands per inch.

16. The method of claim 1 wherein the vinyl layers are heated for up to 1 minute in an oven set at a temperature of at least 170 degrees Celsius and the scrim coated with adhesive is heated for up to 1 minute in an oven set at least at 98 degrees Celsius.

17. A method as claimed in claim 1 further comprising a method for tinting the laminate a particular color.

18. A method for manufacturing a translucent laminate, said laminate consisting of at least one woven scrim layer disposed between at least two outer vinyl translucent layers; said method comprising:

- a. A step for substantially coating said scrim with an adhesive comprised of a mixture of methyl ethyl ketone, isocyanate and polyurethane;
- b. A step for substantially removing said adhesive from the interstices between the warp and fill of said scrim;
- c. A step for heating said scrim coated with said adhesive for at least 30 seconds in an oven set between 98 and 104 degrees Celsius and heating said vinyl layers for at least 30 seconds in an oven set at a temperature between 175 and 180 degrees Celsius; and
- d. A step for bringing said scrim and said vinyl layers together under sufficient pressure and at a suitable temperature such that said vinyl layers bond to said scrim.

19. A method for manufacturing a translucent laminate, said laminate consisting of at

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least one woven scrim layer disposed between at least two outer vinyl translucent layers, wherein the scrim layer is comprised of a warp and a fill each with a density of between 1 to 20 strands per inch and a thickness between 500 to 2000 Denier;

said method comprising:

- a. A step for substantially coating said scrim with an adhesive comprised of a mixture of methyl ethyl ketone, isocyanate and polyurethane;
- b. A step for substantially removing said adhesive from the interstices between the warp and fill of said scrim;
- c. A step for heating said scrim coated with said adhesive for at least 30 seconds in an oven set at a temperature of at least 98 degrees Celsius and heating said vinyl layers for at least 30 seconds in an oven set at a temperature of at least 175 degrees Celsius; and
- d. A step for compressing said scrim and said vinyl layers together with a force between 40 and 60 kilograms per square centimeter at a suitable temperature such that said outer vinyl layers bond with said scrim.

20. A translucent laminate product produced by the method as claimed in any one of the preceding claims.